December-17-12 3:09:32 PM

94411

Page 1

Item 1D: D2344 Accept *N900040100* Setup Start **Revision ID:** Item Name: Litter Deck Plate, 350 **Start Date:** 17/12/2012 Start Qty: 12.00 *12* Cust Item ID: **Customer:** Reference: Run Start Approvals: Process Plan: MLT Date: 12-12-17 Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D2344 Rev F 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per dwg 2024.063 2-deburr as required 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0.00 Memo Quality Control

												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE					
									•			QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST D	Έ	PARTMENT/	PROCESS		
WOLK Old	C1.					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part	No.					Scrap			Machining	Small Fab		Prod	d. Eng. Coor.		Quality
						Use-as-is			noforming	Finishing			e/Packaging		Other
NCR	No.					Work Order Update			Large Fab	Composite			Supplier	_	
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Root					B	ption of work order update		Initial	Act			Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data															
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Other															
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	L	Bending				Bend		Grain				Ovalized			Pressure/Forced
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		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	et		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	Jnclear [Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	Γ		Part Moved			-
		Heat Trea	it		Г	Countersink		Mislabe	eled	Γ		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:09:32 PM Item ID: D2344 Accept *N900040100* Setup Start **Revision ID:** Item Name: Litter Deck Plate, 350 Start Date: 17/12/2012 Start Qty: 12.00 Cust Item ID: **Required Date:** 02/01/2013 **Req'd Qty:** 12.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp 120 QC8- Inspect parts - second check *120* OC Memo Quality Control 130 0.00 Small Fab *130* Small Fab Memo 0.00 Small Fab 1-Deburr sharp edges 2-Countersink holes per Dwg D2344 140 QC5- Inspect part completeness to step on W/O *1<u>4</u>0* Memo Quality Control

												DQA:	Date:			
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	AANCE / UPDATE				•		
										-		QA Closed:	Date:	· .		
Nork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		i	Ŭ ⊢	II Fab shing	Water Je Prod. Eng. Coo Rec/Store/Packagin Supplie		Engineering Quality Other		
Root					Desc	rip	tion of work order update		nitial	Action		Sign &				
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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Land	ng (7			. г	_	General Bend		Grain			Ovalized	<u></u>	Pressure/Forced		
	-	Bending Centre No	ot Concer	ntric to (_{2/5}		BOM/Route	-	Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	H	Cracks					Broken/Damaged			on Incomplete		Part Incorred		Weld		
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs Contamination				Contamination		Mainte	nance		Part Moved		_			
		Heat Treat Countersink					Countersink		Mislabe	led		Positioned V	Vrong	_		
	Inspection Strip in Tube Cut Too Short					Cut Too Short		Misread			Power Loss/	Surge	Other			
		Ripples in	Bend				Drill Holes	Offset								
		Torque W	aves in E	xtrusion	· [Drawing		Out of 0	Calibration	-					
		Turning S	equence		Γ		Finish		Out of 9	Sequence						

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:09:32 PM

Item ID: D2344 Accept *N900040100* Setup Start **Revision ID:** Item Name: Litter Deck Plate. 350 Start Date: **Start Qty: 12.00** 17/12/2012 **Cust Item ID: Required Date:** 02/01/2013 Req'd Qty: 12.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Date:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 150 Chemical Conversion Coat per QSI005 4.1 0.00 *150* HandFinish Memo 0.00 Hand Finishing 155 QC7-Inspect Chemical Conversion Coat 0.00 14 \$ 13-1-9 *155* QC Memo 0.00 Quality Control Black Sandtex(Ref: 4.3.5.7) per QS 160 0.00 *160* Powdercoat 0.00 Powder Coating QVEN TEMPERATURE:

NCD	Van / Na	MORE ORDER NON CONFORMANCE / LIROATE	DQA:_
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	OA Closed:

NCR:	'es	/ No					WORK ORDER NON-C	.Ui	NFORI	HANCE / UPI	JAIE	Q.	A Closed:	Dat	œ:	
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Part N	-						Rework Scrap	Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.				Engineering Quality	
NCR N	lo.						Use-as-is Work Order Update		ľ	oforming Large Fab	Finishing Composite					Other
Root					Des	cri	otion of work order update	Ī	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		_	or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	1	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining	ip/Tooling erator terial up er cess uplier ining upproved															
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Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/U nance Ied	Jnclear	Ov Pa Pa Pa	valized ver/Under art Incorrec art Lost/Mis art Moved ositioned W ower Loss/S	t ssing /rong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	\dashv	Wave/Twi		e	ŀ		Folio	-	1	Dimensions		_				

Date: ___

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:09:32 PM Item ID: D2344 Accept *N900040100* Setup Start **Revision ID:** Item Name: Litter Deck Plate, 350 **Start Date:** 17/12/2012 Start Qty: 12.00 **Cust Item ID: Required Date:** 02/01/2013 Req'd Qty: 12.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: QC: ____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 170 QC3- Inspect Part Finish 0.00 *170* QC 0.00 Memo Quality Control 180 Identify as per dwg & Stock Location: *180* Packaging Memo 0.00 Packaging 190 QC21- Final Inspection - Work Order Release 0.00 *190* QC Memo 0.00 Quality Control

												DQA:	Date	•		
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPDATE			_	· · ·		
						_			· ····			QA Closed:	Date	:		
Nork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part							Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR	No.						Work Order Update		Large Fab Compo			(CC) Stor	Supplier			
Root					Desc	rip	tion of work order update		nitial	Action		Sign &				
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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Land	ng (Gear					General									
		Bending			ſ		Bend		Grain	•		Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to (o/s		BOM/Route	Г	Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks			Γ		Broken/Damaged		Inspect	on Incomplete		Part Incorred	t -	Weld		
	Г	Crushed/0	Crimped.		Γ		Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs	•		ľ		Contamination		Mainte	nance		Part Moved	-			
		Heat Trea	t			\dashv	Countersink		Mislabe	led		Positioned V	Vrong			
	Г	Inspection	n Strip in	Tube	T	\neg	Cut Too Short		Misread	I		Power Loss/		Other		
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	Г	Torque W	aves in E	xtrusior	,		Drawing		Out of (Calibration						
	Γ	Turning Se			ľ	_	Finish		Out of	Sequence						

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-17-12 3:09:37 PM

Work Order ID: 94411

94411

Parent Item:

D2344

D2344

Parent Item Name: Litter Deck Plate, 350

Start Date: 17/12/2012

Required Date: 02/01/2013

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	233.8400	0.745	9.410526			
M2024T3	S 063								**	10.0			Jnn-12-20

Location Loc Qty Loc Code MAT022 233.84 119916 0.2 121197 21.34 123654 27.8 123701 184.5

Page 1

											DQA:	Date	·
NCR:	Yes / No				WORK ORDER NON-O	100	VFOR	MANCE / UP	DATE				
<u></u>	,				T						QA Closed:	Date	•
Work Orde	er [.]				DISPOSITION				AGAINS	T DE	PARTMENT	PROCESS	
Part N	1 1 1 1				Work Order Update			Skid-tube Machining noforming Large Fab	Crosstub Small Fa Finishin Composit	b g		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Act	tion		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	*	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				·									
						AUL	T CATE	GORY					
Landi	ng Gear				General		1				1	_	7
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		1	ion Incomplete ions Incomplete/	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	et _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1	Heat Tre	at		1	Countersink	1	Mislabe	eled		- 1	Positioned V	Vrong	

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94411
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

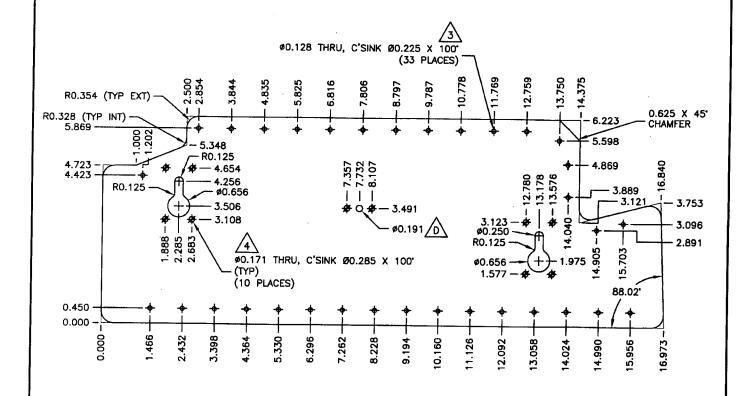
		_				•
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.226	_		ν	Jkmoi
5.598	+/-0.010	5.604"	-		V	
4.869	+/-0.010	4,876"	~		U	
3.889	+/-0.010	3.896	<u> </u>		~	
3.096	+/-0.010	3.099"	-		V	
2.891	+/-0.010	2.897"	_		ν	
16.973	+/-0.010	16,973	_		V	Produsor Skins
0.450	+/-0.010	0.457"	_		Ú	JANA SEE STATE
4.423	+/-0.010	4.427"	~		V	
4.723	+/-0.010	4.726")		V	
1.202	+/-0.010	1,209"	-		V	
5.869	+/-0.010	5.873"	7		ν	
4.654	+/-0.010	4,660"	_		V	
Ø0.656	+0.005/-0.000	0.656"	_		ν	
1.888	+/-0.010	1.893"	_		V	
2.285	+/-0.010	2.291"	<u> </u>		ν	
2.683	+/-0.010	2.688"	_		ν	
Ø0.171	+0.005/-0.000	0.171"	_		V	
3.491	+/-0.010	3.496"	L		V	
Ø0.191	+0.005/-0.000	0.191"			V	
3.123	+/-0.010	3128	_		V	-
1.975	+/-0.010	1,982"	-		V	
Ø0.128	+0.005/-0.001	0.28	- DAG		V	

			10 10 1	 	
Measured by:	Jm	Audited by:	1.289	Prototype Approval:	N/A
Date:	12-12-20	Date:	12 12 21	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
В	07.07.17	Dwg Rev. updated	KJ/JLM	
С	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM J	R



DESIG	1	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED		EV. F
	<u> </u>	100	D2344 SHEET 1	OF 1
DATE			TITLE	SCALE
07.0	06.07		LITTER DECK PLATE, 350	1:3
Α		95.01.14	NEW ISSUE	
В		95.02.09	MOVED KEY HOLES	
D		95.03.06	0.191 WAS 0.197	
E		98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F		07.06.07	C'SINK Ø0.285 WAS Ø0.308	



UNCONTROL : ID COPY SUBJECT TO A LENDMENT WITH ALL SALES

D2344 LITTER DECK PLATE, 350

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 (REF. DART SPEC. M2024T3S)

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
3) COUNTERSINK HOLES MARKED \$\infty\$ TO \$0.225 \times 100^\circ*
4) COUNTERSINK HOLES MARKED \$\infty\$ TO \$0.285 \times 100^\circ*

BREAK ALL SHARP EDGES 0.005 TO 0.010
TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED B) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

RELEASED 07.0c. LZ

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